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D350-567-145 Job Sheet 189908



8574

Part No: D350-567-145

Job Qty: 1 pcs

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 3/4/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DSI9590 REV.G IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	3/4/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S173431

Part: D350-567-145

Job No: 189908

Serial No/Batch: S173431

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92-18 Issue 6 as FAA STC SH989NE

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120	QC 4	1 pcs	3/4/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	DAS
					QC 4 - 46	46 APR 18 2019
130	Packaging 3-1 - Stock - B4B	1 pcs	3/4/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89 DAS
					Packaging 3 - 2 - B4B	46 APR 18 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135	DC - 1 - B4B	1 pcs	3/4/19	0.00 0.00	DC - 1 - B4B	APR 18 2019
					DC - 2 - B4B	
140	QC 21 - FG	1 pcs	3/4/19	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	APR 18 2019 70
						9-89

Part Op 110 - Pick Kit
 Descriptions: 120 - QC4- 100% Inspect kits for completeness
 130 - Identify and pack for shipping as per PPP D350-567-145 Location:FG033
 135 - Document Control - Photocopy bluefile & type labels per PPP D350-567-145 CHG001
 140 - QC21- Final Inspection - Work Order Release

008517

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5131193
AN525-10R6	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5137307
AN525-832R7	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5089346
CB200	Acrylic Adhesive, 3.5G	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5126623
D3802-1-02	Window Seal (\$ Per Foot)	2 ft (2 ea)	110-Packaging 1 - Pick Kit	5104211
D4435-9	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5152437
D4436-041	Aft Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171340
D4441-1	Rubber Seal	2 ft (2 ea)	110-Packaging 1 - Pick Kit	5092162
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5084090
D4971-041	T/R Bellcrank Cover Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5137962
D5076-041	Fwd Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5102193
MS21042L06	Nut	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5148664
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5134763
MS21042L3	Nut	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5130397
MS21059L3	Nut Plate	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5156771
MS35206-229	Screw	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5143702
NAS1149F0332P	Washer	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5157648
NAS1149FN616P	Washer	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5144957
NAS1149FN816P	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5117316-25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-3A	5	241	0
	AN525-10R6	2	409	0
	AN525-832R7	2	135	0
	CB200	1	26	0
	D3802-1	2	118	0
	D4435-9	2	24	0
	D4436-041	1	1	0
	D4441-1	2	472	0
	D4730-020-030	1	9	0
	D4971-041	1	7	0
	D5076-041	1	2	0
	MS21042L06	7	195	0
	MS21042L08	2	1,221	0
	MS21042L3	5	2,821	0
	MS21059L3	2	72	0
	MS35206-229	7	277	0
	NAS1149F0332P	10	1,641	0
	NAS1149FN616P	14	835	0
	NAS1149FN816P	2	225	0

Part Specifications

Specifications could not be found.

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELL CRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELL CRANK COVER ASSEMBLY
	1	1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL	LONGITUDINAL
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	Arm 17.9 in 0.45 m	Moment 69.8 in-lb 0.80 m-kg
		Arm 65.5 in 1.66 m	Moment 255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

REV. F

DRAWING NO.

DSI 9590

SHEET 2 OF 19

SCALE

FLOOR WINDOW CLOSE-OUT KIT

NTS

TITLE

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DATE 15.01.12